










Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT
Job Number	: 46948A		
Estimate Number	: 10176		
P.O. Number	:	Part Number	: D2563
This Issue	: 07/04/2009 S.O. No. :	Drawing Number	: D2563 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: C
Previous Run	: 45167	Material	:
Written By	:	Due Date	: 24/04/2009 Qty: 2 Um: Each
Checked & Approved By	: <u>STU 09.04.07</u>		
Comment	: Est Rev:G 02.07.31 Re-format Location RF		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	D2244116	Step Extrusion	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)			
Pick:			
1 D2244 Step Extrusion			
Batch: <u>B B 33733</u> <u>SAD 09-04-08 (2)</u>			
2.0	D267334	End Plate	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)			
Pick:			
Qty	Part No.	Description	Batch
2	D2673-34	End Cap	<u>335887</u>
<u>PL 09.04.20</u>			
3.0	D2561	Lug	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)			
Pick:			
Qty	Part No.	Description	Batch
2	D2561	Lug Plate	<u>340935</u>
<u>PL 09.04.20</u>			
4.0	D2564	Mounting Angle	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)			
Pick:			
Qty	Part No.	Description	Batch
2	D2564	Mounting Angle	<u>345243</u>
<u>PL 09.04.20</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:17:51 AM

User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 46948A

Part Number: D2563

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 89.70" at 34 deg as per dwg D2563

2-Deburr ends

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343

A/R AL ROD Batch: M110130
M110431

4- Grind

SAD 09-04-08 (2)

LE 09.04.17 2

LE 09.04.17 2

SAD 09-04-20 2

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

RE 09-04-20 (2)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/20 (42)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 09-04-20 (2) 09-04-23 2

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 09.04.23 2

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Inspect for foreign object per QSI 024

2-Weld Remainig End as per Dwg D2563 using DT 8343

A/R AL ROD Batch: M110130

3-Grind

LE 09.04.23 2

LE 09.04.23 2

SAD 09-04-24 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:17:51 AM

User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 46948A

Part Number: D2563

Job Number:



Seq. #: Machine Or Operation: Description :

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

DD 09-04-27

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/27 (X2)

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine then

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M109996

UMO/FL

09/04/28 (X2)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:20

320°

11:50

UMO/FL

09/04/29 (X2)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2563 and QSI 005 4.4

M 111013

FL 09/04/30 (2)

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9/4/30

(2)

Sy

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/01

Job Completion



MF
09-05-01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			


NOTE: Date & initial all entries

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

HAWKESBURY, ONTARIO, CANADA

REV. C

SHEET 1 OF 1

DESIGN	BW
CHECKED	
DATE	

DRAWN BY	PH
APPROVED	PH

DRAWING NO.
D2563

DATE
05.11.14

TITLE
STEP WELDMENT ASSEMBLY

SCALE
1:15

1

96.04.26

NEW ISSUE

572

97.05.14

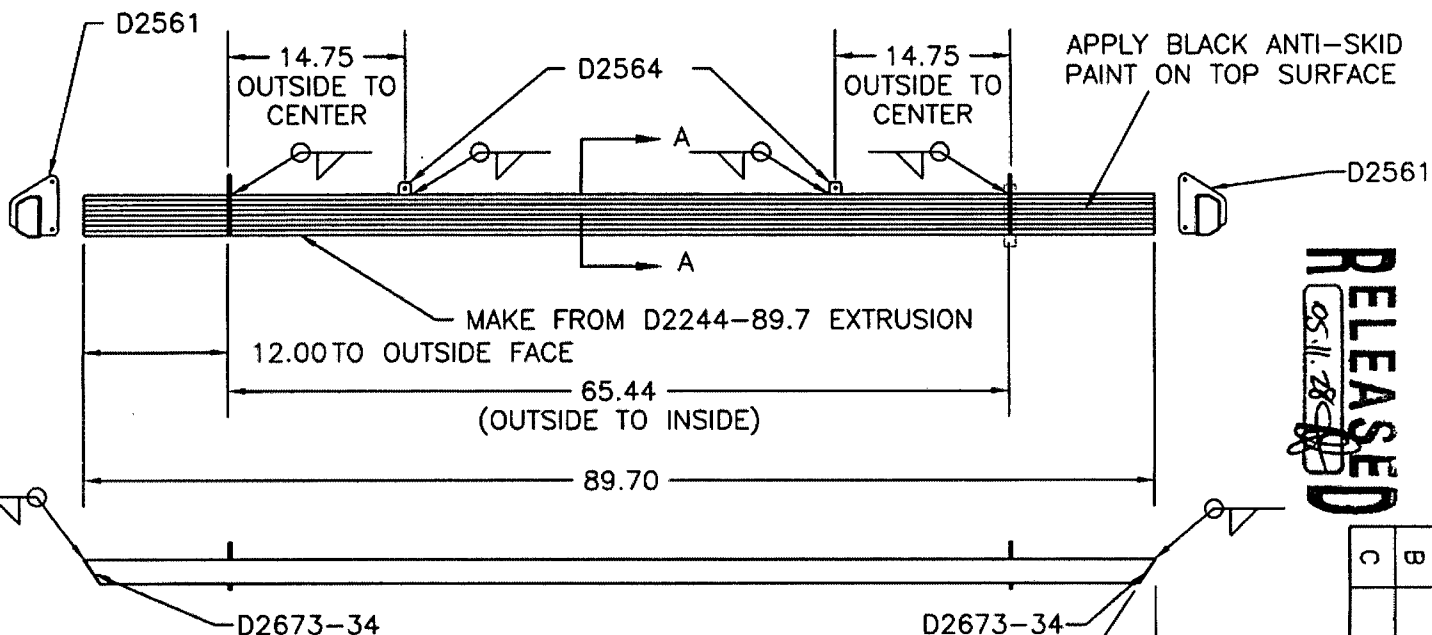
END CAPS CHANGED (WAS D22248)

Q

05.11.14

UPDATE NOTES

05.11.28



APPLY BLACK ANTI-SKID
PAINT ON TOP SURFACE

MAKE FROM D2244-89.7 EXTRUSION

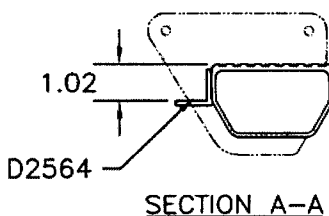
12.00 TO OUTSIDE FACE

65.44
(OUTSIDE TO INSIDE)

89.70

D2673-34

34°
(TYP)



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
3 STEP

D2563 STEP 3 WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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